



FILCORD 37

SARMA PLINA CUPRATA/ COPPER COATED SOLID WIRE

CLASIFICARE / STANDARDS

AUTORIZARI / APPROVALS

AWS A5.28-96 : ER 90S-B3

CARACTERISTICI PRINCIPALE

Sarma plina cuprata, aliata cu 2,25% Cr - 1,00% Mo, pentru rezistente la 600° C utilizate in instalatii termice si petrochimice, putand fi utilizata si pentru reconditionarea prin sudare a pieselor. Indicata pentru sudarea otelurilor rezistente la temperatura, de compozitie chimica similara, ca A335-P22. Se poate utiliza ca gaz de protectie CO₂ sau amestec Ar/CO₂.

MAIN FEATURES

Copper coated solid wire, 2,25% Cr - 1,00% Mo alloyed, for heat resisting steels, up to 600° C, used in thermal or thermic and petrochemical applications: Suitable also for facing on casting, for casting repairs. Suitable for heat resisting steels, such as A335-P22 or casting with same composition. Can be used with Ar/CO₂ Mix or CO₂ shielding gas.

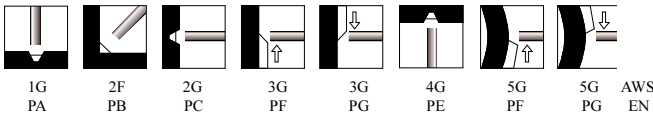
DOMENII DE APLICATIE

Cazangerie
Industria chimica, petrochimica
Fabricarea tevilor

MAIN APPLICATIONS

Vessels, boilers fabrication
Chemical, petrochemical industry
Pipes fabrication

POZITII DE SUDARE / WELDING POSITIONS



CURRENT / CURRENT : DC+

GAZ : Ar / CO₂ - CO₂
M2, C1 (EN 439)

ANALIZA CHIMICA A SARMEI % / WIRE CHEMICAL ANALYSIS %

GAZ	C	Mn	Si	S	P	Cr	Mo	Ni	Cu
Mix/CO ₂	0.07 - 0.12	0.40- 0.70	0.40 - 0.70	≤ 0.025	≤ 0.025	2.30 - 2.70	0.90 - 1.20	≤ 0.20	≤ 0.35

CARACTERISTICI MECANICE / MECHANICAL PROPERTIES

GAZ	Trat. termic/Heat treatment	Rm N/mm ²	Rp 0.2 N/mm ²	E% 5d
Mix	Dupa/After 620°C x 1h	≥ 620	≥ 540	≥ 17

AMBALARE STANDARD / STANDARD PACKAGING

Ambalare/ Packaging	Greutate/ Weight	Diametru mm/Diameter mm			
		1.2			
K 300	15 Kg	2605654			

Datele mentionate pot fi modificate fara o notificare prealabila / The above data may change without prior notice.

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